

Work Order ID 85969

85969

Page 1

June-19-12 11:58:13 AM

Item ID: D2353

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Stiffener

Stop

NS2

Start Date: 19/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/19

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2353

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2353

Dwg Rev: C

Prog Rev: C 2-

Deburr if necessary

2034 050

10 0 Jm 12-6-23

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

10 0 Jm 12-6-23

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

10 0 M 12 06 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:

Stop *NS2*

Item Name: Stiffener

Start Date: 19/06/2012 Start Qty: 10.00

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Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Bend per Dwg D2353

40 *SB* 12/06/25

140

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

9 *W* 12/06/25

150

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

9 *Pro* 12-6-26

W/O: 85969

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2353

PAR #: _____

Fault Category: ScrapNCR: ☒ Yes ☐ NoDQA: 12/7/10

Date: 12/07/10

Resolution: _____

Disposition: ScrapQA: N/C Closed: ☒

Date: 12/7/10

NCR: 12-1565

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
120625	130	1 cracked during bending. Found during inspection material	<u>12/6/25</u>	Scrap + Destroy	SB 12/6/25	<u>12/6/25</u>	<u>12/6/25</u>	<u>12/6/25</u>

NOTE: Date & initial all entries

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Item ID: D2353

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Stiffener

Start Date: 19/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

155

QC7-Inspect Chemical Conversion Coat

0.00

155

QC

Memo

0.00

Quality Control

9 ϕ 1273.

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

W121279

3200 F

8-15

8-45

9X ϕ M-L 12/07/03

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

9 ϕ 1273.

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 19/06/2012 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 03/07/2012 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180 Identify as per dwg & Stock Location: ST 225 0.00

180

Packaging

Memo

0.00

Packaging

190	QC21- Final Inspection - Work Order Release	0.00
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190

QC

Memo

0.00

Quality Control

9x

12-7-3

12/7/4

ME

12-08-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 85969

85969

Parent Item: D2353

D2353

Parent Item Name: Stiffener

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: A Removed from 9 Digit 05-11-10 EC
 IPP: B 06.11.15 waterjet EC
 IPP: c 06.12.07 ecn 836 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	255.0500	0.1463	1.54			

M2024T3S 050

2024-T3 .050 sheet

**

Jm 12-6-23

Location

Loc Qty

Loc Code

MAT022

255.05

117684

22.8

121216

90.75

121889

141.5

121216

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Dart Aerospace Ltd

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